

Work Order ID 139908

Monday, December 14, 2015 1:46:45 PM

139908

Page 1

Item ID: D5330-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM **POSITIVE RECALL** Stop ***NS2***
 Item Name: Handle Plate
 Start Date: 12/14/2015 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/14/2015 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: DEC 14 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5330	<u>A2</u> <u>Rev A</u> <u>5.7.14/10</u>								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut as per dwg								
	Prog Rev: <u>A2</u>								
	Dwg Rev: <u>A2</u>								
	Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(2)

12/16/01/04

(2)

12/16/01/04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition		Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER : _____																					

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Page 2

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 Item Name: Handle Plate
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(2)			DAS 38 9-89
			POSITIVE RECALL EFFECTIVE <u>DEC 14 2015</u> AUTH <u>MLJ</u> RELEASED _____ DATE _____						JAN 06 2016
			RD15-1016-01						
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>PRELIM</u> Memo LOCATION: WA004	0.00 0.00				(2)			DAS 38 9-89
									JAN 06 2016
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

POSITIVE RECALL

EFFECTIVE 15-12-14 AUTH MLJ
 RELEASED 5 DATE 17/1/15

RD15-1016-01

to Rev & Drawing attached
 5.7.1.19

MLJ JAN 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Picklist Print

Monday, December 14, 2015 1:46:48 PM

Page 1

Work Order ID: 139908

139908

Parent Item: D5330-1

D5330-1

Parent Item Name: Handle Plate

Start Date: 12/14/2015

Required Date: 12/14/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 15.10.23 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No				sf	107.9250		0.168421			

M304S11GA

304/316 0.125 Sheet

12/16/01/07

Location

Loc Qty

Loc Code

MAT020

107.92498

M128254

33.675

M129545

30.24998

M129972

44

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

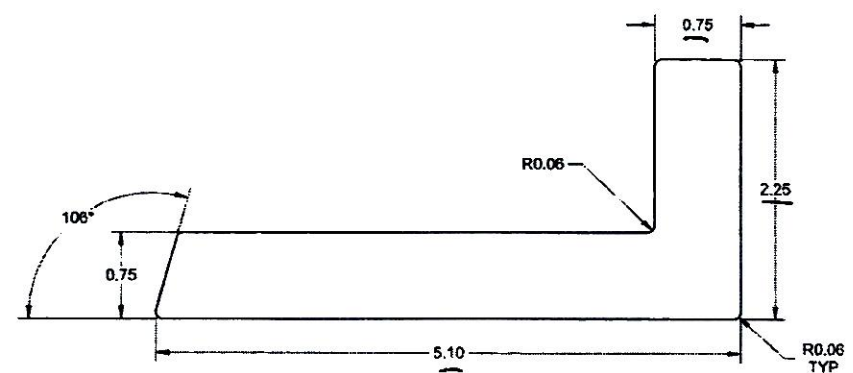
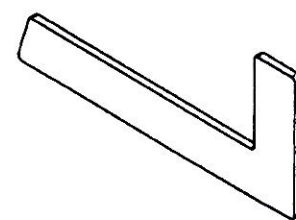
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

RECEIVED ADVISORY
15 AUG 1987



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139908 ML5
1572-14

D5330-1 HANDLE PLATE

NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET, 0.125 THK, ANNEALED 2B
PER MIL-S-5059 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

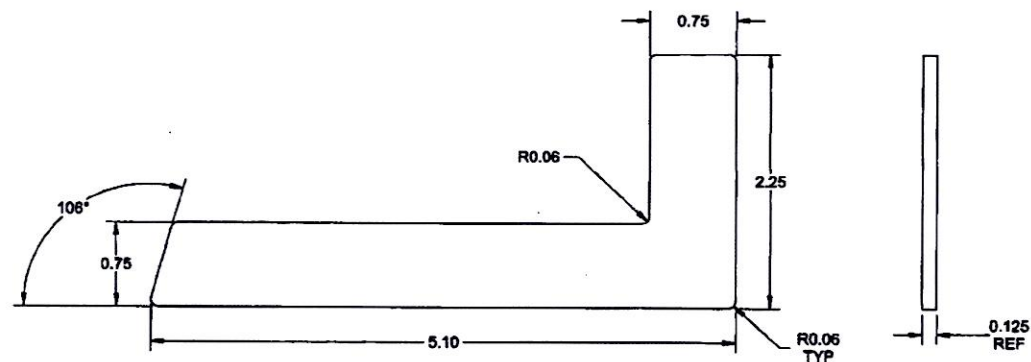
PRELIMINARY ISSUE

A NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	AK		
MFG. APPR.	DD		
APPROVED			
DE APPR.			
DATE	15.08.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D5330** REV. A2
SHEET 1 OF 1
TITLE **HANDLE PLATE** SCALE **NTS**

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NOT TO BE USED FOR ANY PURPOSES NOT COVERED BY THE AUTHORIZED RELEASE WHICH REMAINS THE PROPERTY
OF DART AEROSPACE LTD.



D5330-1 HANDLE PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.125 THK, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

RELEASED
2016-01-21
Ew 16-24

APPROVED

A NEW ISSUE		RF	15.08.10
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5330	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	HANDLE PLATE	NTS
DATE	15.08.10	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED TO ANY OTHER PERSONS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Purchase Order Receipt Listing

Page 1 of 2

Friday, August 01, 2014 8:42:30 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO25193 Receipt Dates from 8/1/2014 to 8/1/2014 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID/Vendor Name	VC-RYS001 Ryerson Canada										
PO25193	1		M304B0.250X4.000 x f		8/1/2014	8/1/2014	12.0000	\$6.38	0.0000	0	\$76.52
CAD	No		304 BAR .250 x 4.00 f		12.0000	DESJ02		\$76.52	0.0000	0	
			M129972								
	2		M304S11GA sf		8/1/2014	8/1/2014	192.0000	\$8.74	0.0000	0	\$1,677.96
	No		304/316 0.125 Sheet sf		192.0000	DESJ02		\$1,677.96	0.0000	0	
			M129972								
	3		M304S14GA sf		8/1/2014	8/1/2014	128.0000	\$5.46	0.0000	0	\$699.15
	No		304SS sheet .080 sf		128.0000	DESJ02		\$699.15	0.0000	0	
			M129972								
	4		M6061T6B0.625X02. f		8/1/2014	8/1/2014	12.0000	\$3.44	0.0000	0	\$41.34
	No		6061-T6 Bar .625 x f		12.0000	DESJ02		\$41.34	0.0000	0	
			500								
			6061-T6 Bar .625 x f								
			2.50								
			M129972								
	5		M6061T6B2.000X05. f		8/1/2014	8/1/2014	12.0000	\$22.04	0.0000	0	\$264.52
	No		000		12.0000	DESJ02		\$264.52	0.0000	0	
			6061T6 Bar 2.00 x f								
			5.000								
			M129972								
	6		M6061T6B2.500X01. f		8/1/2014	8/1/2014	12.0000	\$8.26	0.0000	0	\$99.16
	No		500		12.0000	DESJ02		\$99.16	0.0000	0	
			6061-T6 Bar 2.50 x f								
			1.50								
			M129972								
	7		M6061T6B0.500X02. f		8/1/2014	8/1/2014	12.0000	\$2.76	0.0000	0	\$33.06
	No		500		12.0000	DESJ02		\$33.06	0.0000	0	
			6061-T6 Bar .500 x f								
			2.50								
			M129972								

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-RYS001 Ryerson Canada									
PO25193	8		71401-45		8/1/2014	8/1/2014	1.0000	\$0.00	0.0000	0	\$0.00
CAD	No		PROCUREMENT QUALITY CLAUSES M129972		1.0000	DESJ02		\$0.00	0.0000	0	
Total Received Quantity:											381.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$2,891.71
Total Balance Due Quantity:											0.0000

RYERSON

Packing List Shipping Order

URL for Test Reports: portal.ryerson.com/r
ID: JI6982527

MO #
200 RUE DU CHEMINOT
200 RUE DU CHEMINOT
Phone (450) 424-0153

VAUDREUIL-DORION QC J7V 5V5
VAUDREUIL QC J7V 5V5

Page 1 of 1
SO
*

07/30/14 14:22 CST
AP

Order Number
X6-335785
Purchase Order
PO25193

SOLD TO:
DART AEROSPACE LTD.
1270, ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD.
1270, ABERDEEN STREET

Total Packages: 1

HAWKESBURY ON K6A 1K7 HAWKESBURY ON K6A 1K7 Phone (613) 632-3336

Ship Via	Freight	Customer #	Sales	Tax Status	Contact	Certs	Due Date
Ontario	Our Truck Prepaid/Allowe	1946	21 PG	Taxable		1	07/31/2014
Bill of Lading:	Pro Bill:	Ship Approval:	Ship Date:	Order Date:			
				07/30/2014			

Line No.	Item	Description	Qty Shipped	B/O Quantity
1	7426-7949 TOLE 304	FINI #2B .075 X 48 X 96		
		Tariff Code: 7219.33.00.11		
Qty Comm: 4	Order Qty:	128.0000 USF	Pcs: 4	128.00 USF ✓
(1 -SKID 403)				
Cntrl: X6FT3722 H: M9K2		T: 05M9K2-B	4 pcs Loc EXP	Wt: 403
*** Filled by Initials: MV				

P 17/8/01

Customer/Driver Instructions:
HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR AVANT COTE CHAUFFEUR
CFC ET MTR REQUIS A LA LIVRAISON

Packing List

Received by: _____ Date: _____
Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at www.Ryerson.com,
or from your sales representative, or by calling (800) 268-2680.

Alloys of Aluminum, Copper, Steel Caution:
Processing of this material may present a physical and or health
hazard. See material safety data sheets for further information.

RYERSON

Packing List Shipping Order

URL for Test Reports: portal.ryerson.com/r
ID: JI5372427

MO #
200 RUE DU CHEMINOT
200 RUE DU CHEMINOT
Phone (450) 424-0153

VAUDREUIL-DORION QC J7V 5V5
VAUDREUIL QC J7V 5V5

Page 1 of 3 07/30/14 13:22 CST
SO AP

Order Number

X6-335776

Purchase Order

PO25193

SOLD TO:
DART AEROSPACE LTD.
1270, ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD.
1270, ABERDEEN STREET

Total Packages: 3

HAWKESBURY ON K6A 1K7 HAWKESBURY ON K6A 1K7 Phone (613) 632-3336

Ship Via	Freight	Customer #	Sales	Tax Status	Contact	Certs	Due Date
Ontario	Our Truck Prepaid/Allowe	1946	21 PG	Taxable		1	07/31/2014
Bill of Lading:	Pro Bill:	Ship Approval:	Ship Date:	Order Date:			
				07/30/2014			

Line No.	Item	Description	Qty Shipped	B/O Quantity
1	7131-3563 BARRE DC304L A240 PL 1/4 X 4 X 10-12 PD			
		Tariff Code: 7222.19.00.11		
Qty Comm: 1	Order Qty:	12.0000 UFT	Pcs: 1	12.00 UFT ✓
(1 BOARD 40)				
Cntrl: X6FT1237 H: 501995		T: TR011666	1 pcs Loc EXP	
*** Filled by Initials: SR				
2	7427-6403 TOLE 304 FINI #2B .120 X 48 X 96			
		Tariff Code: 7219.32.00.11		
Qty Comm: 6	Order Qty:	192.0000 USF	Pcs: 6	192.00 USF ✓
(1 -SKID 968)				
Cntrl: X6FS9855 H: L0F2		T: 03L0F2-D	6 pcs Loc EXP	Wt: 968
*** Filled by Initials: MV				
3	7426-7949 TOLE 304 FINI #2B .075 X 48 X 96			
		Tariff Code: 7219.33.00.11		
Qty Comm: 4	Order Qty:	403.0000 USF	Pcs: 0	0.00 USF 403.00

Customer/Driver Instructions:
HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR AVANT COTE CHAUFFEUR
CFC ET MTR REQUIS A LA LIVRAISON

Packing List

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RYERSON

Packing List Shipping Order

URL for Test Reports: portal.ryerson.com/r
ID: JI5372427

MO #

200 RUE DU CHEMINOT

200 RUE DU CHEMINOT

Phone (450) 424-0153

SOLD TO:

DART AEROSPACE LTD.

1270, ABERDEEN STREET

VAUDREUIL-DORION QC J7V 5V5

VAUDREUIL QC J7V 5V5

SHIP TO:

DART AEROSPACE LTD.

1270, ABERDEEN STREET

Page 2 of 3
SO

07/30/14 13:22 CST
AP

Order Number

X6-335776

Purchase Order

PO25193

HAWKESBURY

ON K6A 1K7

HAWKESBURY

ON K6A 1K7

Phone (613) 632-3336

Line No.	Item	Description	Qty Shipped		B/O Quantity	
4	5131-6578	PLAT AL EXTRUDE 6061T6511 COIN CARRE 5/8 X 2-1/2 X 144 Tariff Code: 7604.29.00.19	12.0000	UFT	1	12.00 UFT ✓
Qty Comm: 1		Order Qty:	12.0000	UFT	Pcs: 1	
(1 -BUNDL 22)						
Cntrl: X6FS1660 H: 201407864		T: 795853			1 pcs Loc EXP	
*** Filled by Initials: SR						
5	5131-9788	PLAT AL EXTRUDE 6061T6511 COIN CARRE 2 X 5 X 144 Tariff Code: 7604.29.00.19	12.0000	UFT	1	12.00 UFT ✓
Qty Comm: 1		Order Qty:	12.0000	UFT	Pcs: 1	
(0 -PK/WI 142 LINE 4)						
Cntrl: X6FS8996 H: 201411618		T: 810168			1 pcs Loc EXP	
*** Filled by Initials: SR						
6	5131-9184	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1 1/2 X 2 1/2 X 144 Tariff Code: 7604.29.00.19	12.0000	UFT	1	12.00 UFT ✓
Qty Comm: 1		Order Qty:	12.0000	UFT	Pcs: 1	
(0 -PK/WI 52 LINE 4)						
Cntrl: X6FS5133 H: ES05884		T: 5364327			1 pcs Loc EXP	
*** Filled by Initials: SR						

1/18/14

Customer/Driver Instructions:

HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR AVANT COTE CHAUFFEUR
CFC ET MTR REQUIS A LA LIVRAISON

Packing List

Received by:

Date:

Acceptance of goods constitutes acceptance of our Terms and Conditions, available on our website at www.Ryerson.com,
or from your sales representative, or by calling (800) 268-2680.

Alloys of Aluminum, Copper, Steel Caution:
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hazard. See material safety data sheets for further information.

RYERSON

Packing List Shipping Order

URL for Test Reports: portal.ryerson.com/r
ID: J15372427

MO #

200 RUE DU CHEMINOT
200 RUE DU CHEMINOT

Phone (450) 424-0153

SOLD TO:

DART AEROSPACE LTD.
1270, ABERDEEN STREET

SHIP TO:

DART AEROSPACE LTD.
1270, ABERDEEN STREET

Page 3 of 3

SO

07/30/14 13:22 CST

AP

Order Number

X6-335776

Purchase Order

PO25193

HAWKESBURY

ON K6A 1K7

HAWKESBURY

ON K6A 1K7

Phone (613) 632-3336

Line No.	Item	Description	Qty Shipped	B/O Quantity
7	5131-5463	PLAT AL EXTRUDE 6061T6511 COIN CARRE 1/2 X 2 1/2 X 144 Tariff Code: 7604.29.00.19		
Qty Comm: 1	Order Qty:	12.0000 UFT	Pcs: 1	12.00 UFT
(0 -PK/WI 18 LINE 4)				
	Cntrl: X6C07010 H: Z00224069	T: 748634		1 pcs Loc EXP
*** Filled by Initials: SR				
8	7915-9998	CHARGE ENERGETIQUE/ENERGY CHARGE Tariff Code: 7604.29.00.19		
	Order Qty:	1.0000 LOT	Pcs: 0	1.00 LOT

Customer/Driver Instructions:

HEURES D'OUVERTURE 7H @ 16H LUN @ VEND DECHARGEMENT AU CHARIOT ELEVATEUR_AVANT COTE CHAUFFEUR
CFC ET MTR REQUIS A LA LIVRAISON

Packing List

Received by:

Date:

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or from your sales representative, or by calling (800) 268-2680.

Alloys of Aluminum, Copper, Steel **Caution:**

Processing of this material may present a physical and or health
hazard. See material safety data sheets for further information.

RYERSON

30 JUL 2014

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335785 1
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335785

Part No.: 74267949
TOLE 304 FINI #2B
.075 X 48 X 96

Pcs Wgt
4

NORTH AMERICAN STAIN

Heat Number
M9K2

Test ID
05M9K2-B

Control Number
X6FT3722

4

THIS IS ONLY A LETTER OF COMPLIANCE

To Whom It May Concern,

This is to certify that the material supplied
as above, conforms to the specifications as
outlined in your above order.

AUTHORIZED SIGNATURE



METALLURGICAL TEST REPORT

North American Stainless Canada Inc.
740 Imperial Road North
Guelph, ON N1K1Z3
Canada

740 Imperial Road North

Certificate: 964912 1

Customer: 007035 510

Mail To:
RYERSON CANADA, INC.
C/O X6 - RYERSON VAUDREUIL
200 CHEMINOT STREET
VAUDREUIL, QC J7V5V5

Ship To:
RYERSON CANADA, INC.
C/O X6 - RYERSON VAUDREUIL
200 CHEMINOT STREET
VAUDREUIL, QC J7V5V5

Date: 7/08/2014 Page: 1

Steel: 304L

Finish: 2B

Your Order: 748827

NAS Order: PN 0038932 03

Corrosion: ASTM A262/10 A; 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED. UNS 30403
ASTM A240/13c, A480/13, A666/10; ASME SA240/13, SA480/13, SA666/13
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/13, SA479/13
AMS 5511H XMRK; MIL-5059D AMD3 (X CRN MEAS); MIL-4043B
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; QQS766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Stainless

Product Id	Coil #	Skid #	Thickness	Width	Weight	-----Length-----	Mark	Pieces	Commodity Code
05M9K2 B	05M9K2 B		.0725	48.0000	17.170	COIL	4	1	74266941

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
M9K2	US	.0215	18.1575	.4960	1.7485	.4665	.0859	8.0815	.0340	.0028
SI %										
.2115										

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d o i c r	UTS KSI	20C .2% YS KSI	20C ELONG %-2"	% Hard RB	Tail Hard
05M9K2 B	05M9K2 B	F T	97.58	51.40	46.26	88.00	88.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ABHIJEET BHAVE

7/08/2014

DAPT AEROSPACE LTD.

P.O. - P025193 S.O. - 335785

FAX 001 514

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: 304 sll GA
 DATE: 2014/08/15

PO / BATCH NO.: P025193
M129972

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 4 sheets
 QUANTITY INSPECTED: —
 QUANTITY REJECTED: —

THICKNESS ORDERED: 0.080"
 THICKNESS RECEIVED: 0.079"
 SHEET SIZE ORDERED: 192 sf
 SHEET SIZE RECEIVED: 128 sf

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL	☒ Y N	
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT MATERIAL	Y N	ASTM A 240
CORRECT REF # TO LINK CERT	Y N	119K2
CORRECT MATERIAL IDENTIFICATION	Y N	M304 Sll GA
CORRECT M# ON THE MATERIAL	Y N	M129972
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	u/ur
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>[Signature]</u>		SIGNED OFF BY: _____	
DATE: <u>14/08/15</u>		DATE: _____	

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

RYERSON

30 JUL. 2014

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335776 1
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335776

Part No.: 71313563
BARRE (DC304L) A240 PL
1/4 X 4 X 10-12 PD

Pcs Wgt
1

=====

PHOENIX
Heat Number
501995

Test ID
TR011666

Control Number
X6FT1237

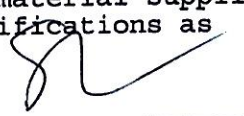
1

Conf
11/08/02

THIS IS ONLY A LETTER OF COMPLIANCE

To Whom It May Concern,

This is to certify that the material supplied
as above, conforms to the specifications as
outlined in your above order.

AUTHORIZED SIGNATURE 

RYERSON

30 JUL. 2014

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335776 2
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335776

Part No.: 74276403
TOLE 304 FINI #2B
.120 X 48 X 96

Pcs Wgt
6

NORTH AMERICAN STAINLESS

Heat Number Test ID
L0F2 03L0F2-D

Control Number
X6FS9855

6

THIS IS ONLY A LETTER OF COMPLIANCE

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outlined in your above order.

AUTHORIZED SIGNATURE



RYERSON

30 JUL. 2014

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335776 4
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335776

Part No.: 51316578
PLAT AL EXTRUDE 6061T6511 COIN CARRE
5/8 X 2-1/2 X 144

Pcs Wgt
1

SERVICE CENTER METAL

Heat Number
201407864

Test ID
795853

Control Number
X6FS1660

1

exp 10/12

THIS IS ONLY A LETTER OF COMPLIANCE

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AUTHORIZED SIGNATURE



30 JUL. 2014

RYERSON

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335776 5
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335776

Part No.: 51319788
PLAT AL EXTRUDE 6061T6511 COIN CARRE
2 X 5 X 144

Pcs Wgt
1

SERVICE CENTER METAL

Heat Number
201411618

Test ID
810168

Control Number
X6FS8996

1

THIS IS ONLY A LETTER OF COMPLIANCE

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outlined in your above order

AUTHORIZED SIGNATURE



RYERSON

30 JUL. 2014

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335776 6
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335776

Part No.: 51319184
PLAT AL-EXTRUDE 6061T6511 COIN CARRE
1 1/2 X 2 1/2 X 144

Pcs Wgt
1

CAN ART
Heat Number
ES05884

Test ID
5364327

Control Number
X6FS5133

1

THIS IS ONLY A LETTER OF COMPLIANCE

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as above, conforms to the specifications as
outlined in your above order.

AUTHORIZED SIGNATURE



30 JUL. 2014

RYERSON

TEST CERTIFICATE

Sold By:
RYERSON CANADA INC.
200 RUE DU CHEMINOT
VAUDREUIL-DORION QC J7V 5V5
GST/TPS REG. # 895962561RT0001Y
QST/TVQ REG. # 1019096102 TQ0001
Tel: 450-424-0153 Fax: 450-424-0853

P/O No: PO25193
Rel :
S/O No: 335776 7
B/L No:
Inv No:

Sold To: (1946)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
Tel: (613)632-3336
Fax: (613)632-4443

ON K6A 1K7

Ship To: (1)
DART AEROSPACE LTD.
1270, ABERDEEN STREET
HAWKESBURY
K6A 1K7

ON

CERTIFICATE of COMPLIANCE

Cert. No: 335776

Part No.: 51315463

~~PLAT AL EXTRUDE~~ 6061T6511 COIN CARRE
1/2 X 2 1/2 X 144

Pcs Wgt
1

KAISER

Heat Number
200224069

Test ID
748634

Control Number
X6C07010

1

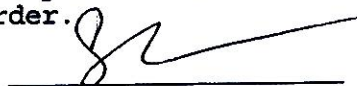
certified

THIS IS ONLY A LETTER OF COMPLIANCE

To Whom It May Concern,

This is to certify that the material supplied
as above, conforms to the specifications as
outlined in your above order.

AUTHORIZED SIGNATURE



Fax Server

7/30/2014 1:32:00 PM FAX 1-800-111-1111

DART AEROSPACE LTD. P.O. - P025193 S.O. - 335776

PHOENIX TUBE COMPANY, INC.

Manufacturer of Stainless Ornamental and Structural Tubing

CERTIFICATION OF TEST

Sold To: RYERSON CANADA
200 RUE DU CHEMINOTShip To: RYERSON CANADA
200 RUE DU CHEMINOTVAUDREUIL-DORION QC J7V
CANVAUDREUIL-DORION QC J7V
CAN

CUSTOMER ORDER#: 754390

Phone# 4240153

Ext:

CUST REF NBR:

ORDER#: 339370

DATE SHIPPED: 06/02/14

QTY SHIPPED: 1065.0

SIZE: 4" X 1/4" HRAP

GRADE: 304L

NO WELD: BAR

SOURCE: USA D

HEAT#: 501995

VENDOR: OUTOK

TEST REPORT#: TR011666

Report Date: 03/04/14

Specification:

CHEMISTRY THIS COLUMN:

ASTM A276-13
ASME SA276-13 COND. A
ASTM A479-13
ASME SA479-13
NO WELD REPAIR
EN 10204 2.2ASTM A262-13, PRACT/ E
CORROSION OK, HRAP
ASTM A484-13
ASME SA484-13
ASTM A480-13
ASME SA 480-13ASTMA240-13
ASME SA240-13
MILS 5059D AMEND 3
AMS5553H/AMS5513J
NACE MR0175/01 / MR0103
AMS 5639H / AMS 5647JTYPE 304L/304 DUAL CERTIFIED
UNS# 30400 / 30403
ASTM A868-10
QQ-S-763F, COND A
QQ-S-766D, COND. A
CHEMISTRY ONLY

MERCURY IS NOT USED BY US AS AN ALLOYING MATERIAL NOR IS METALLIC MERCURY HANDLED IN THE VICINITY OF OUR PROCESSING LINES. WE ARE NOT PRESENTLY AWARE OF ANY MERCURY CONTAMINATION. MATERIAL HAS BEEN HEATED TO A MINIMUM OF 1900 DEG. F AND IS SUBSEQUENTLY COOLED RAPIDLY TO PREVENT CARBIDE PRECIPITATION

Chemical Analysis

C	MN	P	S	SI	CR	NI	MO	CU	CO	N2	TI
.026	1.56	.026	.001	.38	18.06	8.02	.22	.352	0	.08	0

Physical Analysis

Hardness	YIELD		TENSILE		OTHER	
	PSI	MPA	PSI	MPA	Percent EL	Percent RA
RB 82	44525	0	93836	0	58	0

THE CHEMICAL ANALYSES ARE CORRECT AS CONTAINED IN OUR CORPORATE RECORDS.
PHYSICAL PROPERTIES ARE DETERMINED WHILE MATERIAL IS IN STRIP FORM.

Melted & Manufactured in the USA FAR BAA complies, DFARS BAA complies, FAR TAA complies

CERTIFIED BY Quality Control Dept.



1185 WIN DR, BETHLEHEM, PA. 18017 - (610) 865-5337

FAX NUMBER: 610-865-4073



METALLURGICAL TEST REPORT

NORTH AMERICAN STAINLESS
6870 HIGHWAY 42 EAST
GHENT, KY 41045

6870 HIGHWAY 42 EAST

Certificate: 922956 3

Customer: 007035 510

Mail To:
RYERSON CANADA, INC.
C/O X6 - RYERSON VAUDREUIL
200 CHEMINOT STREET
VAUDREUIL, QC J7V5V5

Ship To:
RYERSON CANADA, INC.
C/O X6 - RYERSON VAUDREUIL
200 CHEMINOT STREET
VAUDREUIL, QC J7V5V5

Date: 2/26/2014 Page: 1

Steel: 304L

Finish: 2B

Your Order: 745848

NAS Order: PN 0035129 01

Corrosion: ASTM A262/10 A, 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED. UNS 30403
ASTM A240/13a, A480/13, A666/10; ASME SA240/13, SA480/11a, SA666/13
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/11, SA479/11
AMS 5511H XMRK; MIL-5059D AMD3 (X CRN MEAS); MIL-4043B
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; QQS766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product Id	Coil #	Skid #	Thickness	Width	Weight	-----Length-----	Mark	Pieces	Commodity Code
03LOF2 D	03LOF2 D		.1163	48.0000	9,750	COIL	6	1	74275694

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
LOF2 ✓	US	.0217	18.1330	.5390	1.8110	.3700	.0673	8.0630	.0340	.0010
SI %										
.2820										

MECHANICAL PROPERTIES

Product Id#	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard
03LOF2 D	03LOF2 D	F T	92.56	49.03	51.06	87.00	85.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ERIC HESS

2/26/2014

FAX DRIVER
 DART AEROSPACE LTD. P.O. - P025193 S.O. - 335776

**Service Center Metals**5850 Quality Way
Prince George, VA 23875**CERTIFIED INSPECTION REPORT AND TEST RESULTS
FOR EXTRUDED PRODUCTS**

OUR ORDER NUMBER	ITEM
202551	6

BILL TO	MANIFEST NUMBER	DIE NUMBER	DATE OF SHIPMENT
Ryerson Canada, Inc. (Toronto)	222745	RB0107	4/22/2014
SHIP TO	CUSTOMER PO	ALLOY / TEMPER	SALESPERSON
Ryerson Canada, Inc. (Montreal)	752290	6061-T6511	D.Schroeder (Canada)
Quantity Certified 529 lbs 24 pcs	CUSTOMER PART NUMBER	DESCRIPTION	
	51316578	SCRB .625x2.500	

CERTIFICATION
ASTM-B221-13 StencilCont
SPECIFICATION
AMS-QQA-200/8 - 1997

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA.

Items produced and certified as 6061-T6511 also meet the requirements of 6061-T6

Mechanical Properties		Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
Tests	Lot No.		min	max	min	max	min	max
2	201407864	4/22/14	48.90	49.50	46.40	47.70	14.20	14.80

Chemical Composition for Aluminum Alloy 6061

Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	AL	Others		Melt Source:
											Each	Total	
01121404	6061	0.74	0.36	0.31	0.10	0.86	0.09	0.09	0.02	97.43	0.03	0.10	United States of America

Calvin J. Wiggins, Director of Quality & Technical Services

Print Date: 4/22/2014

Rev. 3/23/11 - UMS

DART AEROSPACE LTD. P.O. - P025193 S.O. - 335776

FAX DELIVER



Service Center Metals

5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
206422	9

BILL TO Ryerson Canada, Inc. (Toronto)	MANIFEST NUMBER 227443	DIE NUMBER MRB0855	DATE OF SHIPMENT 6/10/2014
SHIP TO Ryerson Canada, Inc. (Montreal)	CUSTOMER PO 754493	ALLOY / TEMPER 6061-T6511	SALESPERSON D.Schroeder (Canada)
Quantity Certified 1,139 lbs 8 pcs	CUSTOMER PART NUMBER 51319788	DESCRIPTION MQRB 2.000 +.024 x 5.000 +.034	

CERTIFICATION ASTM-B221-13 StencilCont
SPECIFICATION AMS-QQA-200/8 - 1997

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA.

Items produced and certified as 6061-T6511 also meet the requirements of 6061-T6

Mechanical Properties

Tests	Lot No.	Test Date	Ultimate Tensile Strength (KSI)		Yield Strength (KSI)		Percent Elongation	
			min	max	min	max	min	max
1	201411204	6/4/14	50.70	50.70	47.70	47.70	19.20	19.20
			min	max	min	max	min	max
1	201411618 ✓	6/8/14	50.30	50.30	45.80	45.80	18.10	18.10

Chemical Composition for Aluminum Alloy 6061

Cast Number	Alloy	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	AL	Others		Melt Source:
											Each	Total	
05231402	6061	0.72	0.34	0.31	0.12	0.89	0.15	0.05	0.02	97.40	0.03	0.10	United States of America
1m140530b-0501	6061	0.74	0.36	0.32	0.10	0.88	0.10	0.05	0.02	97.44	0.03	0.10	United States of America

Print Date: 6/10/2014

Calvin J. Wiggins, Director of Quality & Technical Services

Rev. 9/23/11 - UMS

fax server
DART AEROSPACE LTD. P.O. - P025193 S.O. - 335776

DART AEROSPACE LTD. P.O. - PO25193 S.O. - 335776

CAN ART ✓
ALUMINUM EXTRUSION INC.Material Test ReportManifest: 277812Ship To: Ryerson Vaudreuil
200 Rue Du cheminot
Vaudreuil-Dorion, QC J7V 5V5Our Order: 862144 - 1 ✓ Cust P.O.: 753055
Die: ES05884 ✓ Part: 5131-9/84
Alloy Temper: 6061 T6511 ✓ Description: 1.500 x 2.500
Print Date: 5/14/14**Chemical Composition Range**

6061	<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>OtherEach</u>	<u>OtherTotal</u>
Min	0.40		0.15		0.8	0.04				
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15

Mechanical Properties

Strength ksi

<u>Sample ID</u>	<u>Cast #</u>	<u>Lot #</u>	<u>Test Date</u>	<u>Ultimate Tensile</u>	<u>Yield 2% offset</u>	<u>Elongation 2" gage length</u>
47139	14041191A	A11	5/9/14	45.02	41.11	20.0

Applicable Specifications: ASTM B221-13 QQA200/8

Country of Origin: ONTARIO, CANADA

Can Art Aluminum Extrusion Inc. certifies that materials shipped under this order have been inspected and tested in accordance with Aluminum Association and agreed upon customer specifications. Can Art assumes no liability for additional costs which may be incurred during the customer's manufacture and sale of its products, and is subject only to the replacement of any materials not within agreed upon specifications provided written notification is received by Can Art within 30 days from the date of shipment.

Eric Hotte - Tensile Testing

Authorized: _____


Evan Eng, Quality Assurance Mgr.

KAISER

ALUMINUM

FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS, LLC
5205 KAISER DRIVE
KALAMAZOO, MI 49048

CERTIFIED TEST REPORT

<http://Online.KaiserAluminum.com>

CUSTOMER PO NUMBER: 748634-1		CUSTOMER PART NUMBER: 51315463		PRODUCT DESCRIPTION: .500 X 2.500 RECT BAR	
KAISER ORDER NUMBER: 659494	LINE ITEM: 001	SHIP DATE: 01/28/2014	KAISER LOT NUMBER: Z00224069	ALLOY: 6061	TEMPER: T6511
WEIGHT SHIPPED: 988.000 LB	QUANTITY: 56.000 PCS	B/L NUMBER: 608077	DIAM/DAF/THKNS: 	WIDTH: 	LENGTH: 12.000 FT
SHIP TO: RYERSON CANADA 200 RUE DU CHEMINOT VAUDREUIL-DORION, PQ J7V 5V5 CANADA			SOLD TO: RYERSON 161 THE WEST MALL ETOBICOKE, ON M9C4V8 CANADA		

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CONDUCT.	BEND
Z00224069	0001	1	46.0	42.2	19.1	RE 96	N/A	N/A
Z00224069	0001	2	45.5	41.7	18.1	RE 95	N/A	N/A
Z00224069	0001	3	45.6	42.1	19.1	RE 95	N/A	N/A
Z00224069	0001	4	45.2	41.6	19.0	RE 96	N/A	N/A
Z00224069	0001	5	44.8	41.3	20.7	RE 94	N/A	N/A
Z00224069	0001	6	46.5	42.8	19.3	RE 97	N/A	N/A
Z00224069	0001	7	45.7	41.8	18.3	RE 96	N/A	N/A
Z00224069	0001	8	46.2	42.5	19.0	RE 96	N/A	N/A
Z00224069	0001	9	46.2	42.6	13.7	RE 96	N/A	N/A
Z00224069	0001	10	46.2	41.4	19.2	RE 97	N/A	N/A
Z00224069	0002	1	47.2	44.2	18.0	RE 96	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
103407	.68	.24	.25	.10	.94	.09	.02	.03	.00	.00	.00	.01	.04

Applicable Requirements:

ASTM-B221-13 STENCILED ASME-SB221 1998 SECT II AMS-QQ-A-200/8 97(REF 2012) UNS#A96061
(T6511 also conforms to T6-not applicable to other tempers)

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA
MERCURY IS NOT A NORMAL BACKGROUND ELEMENT IN ALUMINUM ALLOYS. NEITHER MERCURY NOR ANY
OF ITS COMPOUNDS ARE UTILIZED BY KAISER ALUMINUM IN THE MANUFACTURE OF THIS MATERIAL.

Plant Serial: 00121368
Kaiser Order Number: 659494
Line Item: 001



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25193

Purchase Order Date 7/29/2014

PO Print Date 7/29/2014

Page Number 1 of 4

Order From :
RYERSON
200 DU CHEMINOT
VAUDREUIL, QUEBEC J7V 5V5

VC-RYS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED

Contact Name
Vendor Phone 450-424-0153

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

M 125972

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M304B0.250X4.000	304 BAR .250 x 4.00	8/1/2014 Yes 8/1/2014		12.00 f	\$6.80	\$81.65

MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE
AS PER ASTM A276 OR ASTM A240
NOTE: AISI 303 NOT ACCEPTABLE

Line Total: \$81.65

M	M304S11GA	304/316 0.125 Sheet	8/1/2014 Yes 8/1/2014		192.00 sf	\$9.33	\$1,790.40
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MATERIAL: AISI 304/316 SS SHEET ANNEALED
AS PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240

P-14/8/1

Line Total: \$1,790.40

Note:

7/29/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25193**

Purchase Order Date 7/29/2014

PO Print Date 7/29/2014

Page Number 2 of 4

Order From :
RYERSON
200 DU CHEMINOT
VAUDREUIL, QUEBEC J7V 5V5

VC-RYS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-424-0153

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

3	M304S14GA	304SS sheet .080	8/1/2014	128.00	✓	\$5.83	\$746.00
			Yes	sf			
			8/1/2014				

MATERIAL: AISI 304/316 SS SHEET ANNEALED
AS PER MIL-S-5059 OR AMS 5513 (304)
OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240

Line Total: \$746.00

4	M6061T6B0.625X02.500	6061-T6 Bar .625 x 2.50	8/1/2014	12.00	✓	\$3.68	\$44.11
			Yes	f			
			8/1/2014				

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR
ASTM B221

Line Total: \$44.11

5	M6061T6B2.000X05.000	6061-T6 Bar 2.00 x 5.000	8/1/2014	12.00	✓	\$23.52	\$282.24
			Yes	f			
			8/1/2014				

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR
ASTM B221

Note:

7/29/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25193**

Purchase Order Date 7/29/2014

PO Print Date 7/29/2014

Page Number 3 of 4

Order From :
RYERSON
200 DU CHEMINOT
VAUDREUIL, QUEBEC J7V 5V5

VC-RYS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-424-0153

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

Line Total: \$282.24

6	M6061T6B2.500X01.500	6061-T6 Bar 2.50 x 1.50	8/1/2014 Yes 8/1/2014	12.00 f	✓	\$8.82	\$105.80
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MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR
ASTM B221

Line Total: \$105.80

7	M6061T6B0.500X02.500	6061-T6 Bar .500 x 2.50	8/1/2014 Yes 8/1/2014	12.00 f	✓	\$2.94	\$35.28
---	----------------------	-------------------------	-----------------------------	------------	---	--------	---------

MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
AS PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8 OR AMS 4160 OR ASTM B211 OR
ASTM B221

Line Total: \$35.28

Note:

7/29/2014



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO25193

Purchase Order Date 7/29/2014

PO Print Date 7/29/2014

Page Number 4 of 4

Order From :
RYERSON
200 DU CHEMINOT
VAUDREUIL, QUEBEC J7V 5V5

VC-RYS001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-424-0153

Ship To Contact
Ship To Phone
Ship Via: Yours ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency CAD
FOB Destination-Collect

8	71401-45	PROCUREMENT QUALITY CLAUSES	8/1/2014	1.00	\$0.00	\$0.00
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No

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of materials conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

8/1/2014

Line Total: \$0.00

PO Total: \$3,085.48

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 7/29/2014